0.00

0.00

BIL 4-5

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Dart Ae	rospace Li	td									•*
W/O:				WORK	ORDER CHANG	ES					•
DATE	STEP	PRO	OCEDURE	CHANGE		В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
Part No):	PAR #:	Fault	Category	·	NCR: \	es N	lo DQ	A :	Date: _	
Resolution: Dispersion			osition:		QA: N/	C Clo	sed:		Date: _		
NCR:		,	WORK (RDER	NON-CONFORM	ANCE (N	ICR)			=	
DATE	0750	Description of NC		Corrective Action Section I			verification			Approval	Approva
DATE	STEP	Section A	Initia Chief E	1	Action Description Chief Eng		gn & Date		tion C	Chief Eng	QC Inspect



Tuesday, April 05, 2011 7:57:27 AM

Item ID:	I	tem	ID	:
----------	---	-----	----	---

D3199-4

Accept



Setup Start

Stop



Revision ID:

Item Name:

Bracket, Fwd RH

Start Date:

4/5/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Tool ID

Start Run

Required Date: 4/6/2011

QC: ____

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

120

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Set Up/ **Run Hours**

0.00

Tool # Plan Code

Reject Accept **Qty** Qty

Reject Number

Insp. Stamp

Memo

0.00 Enloylor

130

Brake NC

Brake NC

Bend as per dwg

Small Fab

0.00

0.00

SB Moulos

Memo

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0000 Ill oulos

Dart Ae	rospace	e Ltd							y."
W/O:				WORK ORDER CH	ANGES				•
DATE	STEP	PRO	OCEDURE (CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
								·	
		· · · · · · · · · · · · · · · · · · ·							
Part No):	PAR #:	Fault	Category:	NCR: Ye	s No DQA:	:	Date:	
	R	esolution:	Dispo	sition:	QA: N/C	Closed:	···	Date: _	
NCR:		1	WORK O	RDER NON-CONFO	ORMANCE (NO	CR)			
5.475		Description of NC		Corrective Action Section		Verifica	ation	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	1)	ption Sign Da	າ& ∣ _{Section}		Chief Eng	QC Inspecto
			İ						
.				·					

Page 3

Stamp

Tuesday, April 05, 2011 7:57:27 AM Item ID: D3199-4 Accept Setup Start **Revision ID:** Stop Item Name: Bracket, Fwd RH **Start Date:** 4/5/2011 Start Qty: 1.00 **Cust Item ID:** Required Date: 4/6/2011 Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: Date: Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description Qty Code Qty Number **Run Hours** Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 150 0.00 0.00 Powdercoat Powder Coating 160 QC3- Inspect Part Finish 0.00 0.00 QC Memo Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Dart Ae	rospace L	td							•'
W/O:				WORK ORD	ER CHANGE	S			
DATE STEP		PRO	OCEDURE	CHANGE		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault	Category:		NCR: Yes	No DQA:	Date: _	
	Resolution:		Dispe	sition:	osed:	Date: _			
NCR:		,	WORK (RDER NON-	CONFORMA	NCE (NCF	R)		
5		Description of NC		Corrective Action Section			Verificatio	n Approval	Approva
DATE	STEP	Section A	Initia Chief E		Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspect
								5	
				į.					
								·	
NOTE F	No. 1								

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Tuesday, April 05, 2011 7:57:27 AM

Item ID:

D3199-4

Accept

			5
Ш			

Setup Start



Revision ID:

Start Date:

Bracket, Fwd RH Item Name:

Required Date: 4/6/2011

4/5/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Δ	nn	ro	va	ls:
	บบ	υ	νa	13.

Process Plan:

Memo

Date: Date: **Tooling:**

SPC (Y/N):

Set Up/

Date:

Date:

Run Start

Stop



Stop

Sequence ID/

Work Center ID

180

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

· ')'

11

1.0

0.00

0.00

Tool ID Run Hours

Tool# Plan Code

Accept Qty Qty

Reject Reject Number Insp.

Stamp

M 11-09-7

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** STEP PROCEDURE CHANGE DATE Bv Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section 8	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector				
		•										
								-				
		·										
		- Adaption of the second of th										
						# 4						
NOTE. D	ate & initial a	II antrica										

Picklist Print

Tuesday, April 05, 2011 7:57:34 AM

Work Order ID: 67955

Parent Item: D3199-4

JJ 1 7 7* 4

Parent Item Name: Bracket, Fwd RH



Start Date: 4/5/2011

Required Date: 4/6/2011

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: RevC-prelim DD verified by:EC

11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	92.5000	0.1673	0.176105	•	١,	
											1B(1-4	-5-	

304/316 .040 Sheet

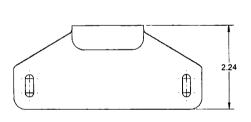
Location	Loc Qty	Loc Code	
MAT020	92.5		
116437	28.5		116437
116623	64		

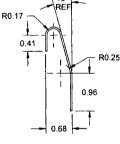


Dart Ae	rospace l	_td								.'
W/O:			V	VORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CH	IANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Ca	itegory:	NC	R: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposi	tion:	QA	: N/C C	losed:		Date: _	
NCR:			WORK OR	DER NON-CONFO	ORMANCE	E (NCI	R)			
DATE	STEP	Description of NC Section A	Initial	Action Descri	Section B ption	Sign Date	& Sect	cation ion C	Approval Chief Eng	Approva QC Inspect
			Chief Eng	Chief Eng		Date			·	
				1						
				·					,	

R0.30 TYP BEND LINES REF R0.01 R0.105 4PL 2.971 GRAIN DIRECTION 2.29² 2.015 REF TYP 1.00 1.090 REF 0.575 0.315 0.400 4.030 4.830

D3199-1F FLAT PATTERN





R0.17

RETURN TO

ENGINEERING

SHOP COPY

UNCONTROLLED COPY

TTO AMENL.
WITHOUT NOTICE
WORK ORDER
NO. 1955

Pli-04-5

DELEASE
2011-03-33

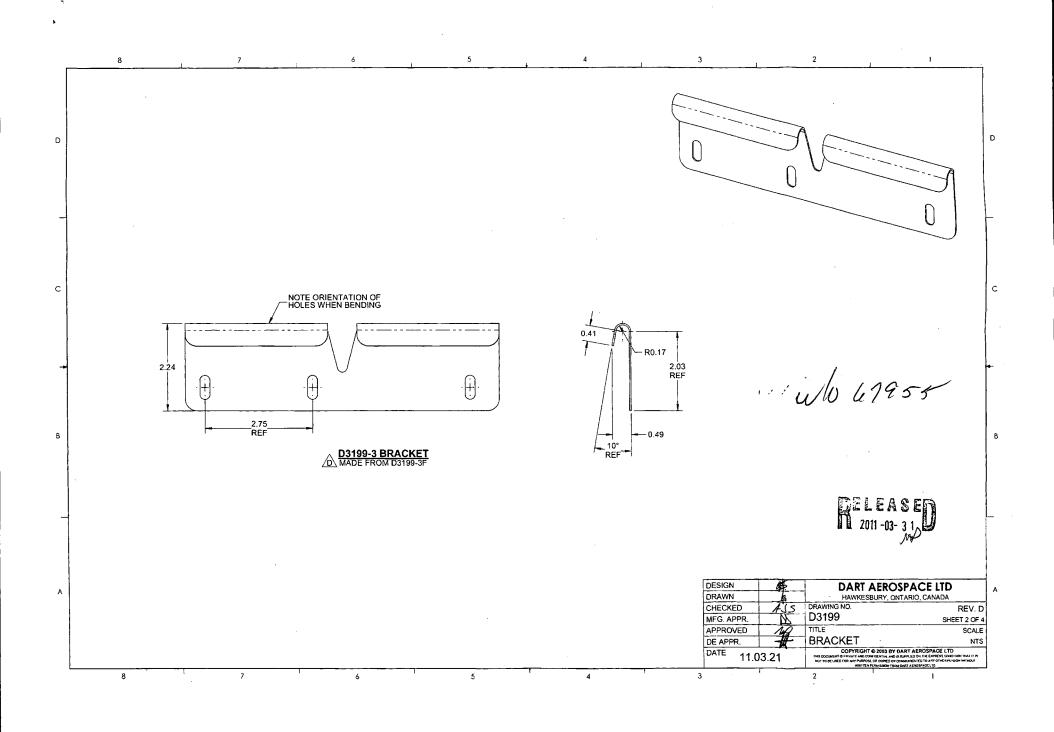
D3199-1 BRACKET MADE FROM D3199-1F

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304520GA
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFICATION: DENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

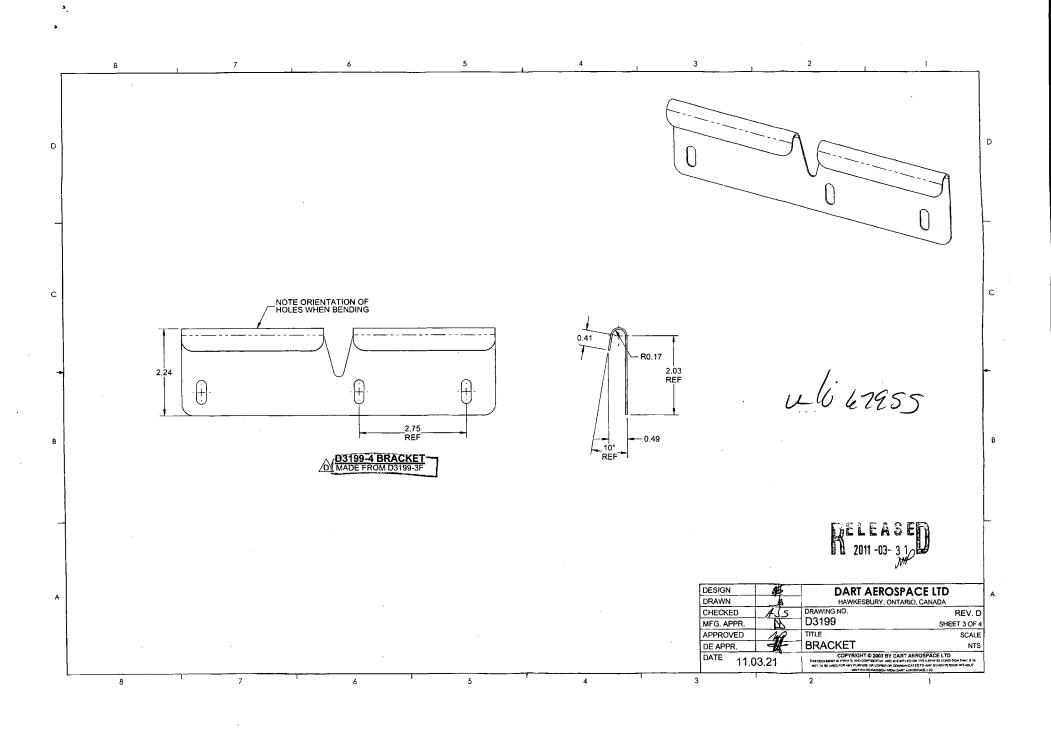
DESIGN	DART AFROSPA	CET	TD.
REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	CP	03.08.05
В	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
С	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79	MB	11.03.21

DESIGN	41	DART AEROS	SPACE LTD			
DRAWN	B	HAWKESBURY, ON	TARIO, CANADA			
CHECKED	435	DRAWING NO.	REV. D			
MFG. APPR.		D3199	SHEET 1 OF 4			
APPROVED	NP.	TITLE	SCALE			
DE APPR.	-41	BRACKET	NTS			
DATE 11.0	3.21	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS TRAVATE AND COST DEFINE, AND STATE OF THE STATES OF THE STATE OF T				

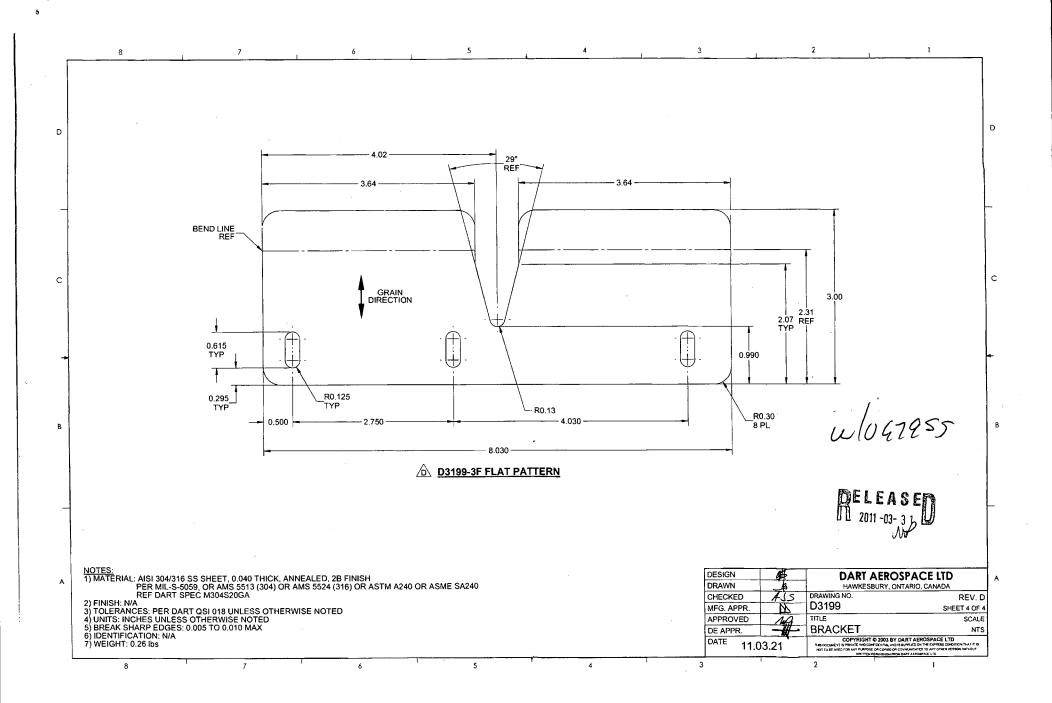
Dart Ae	rospace	e Ltd			4						•
W/O:				V	VORK ORDER CHANGES	·					4
DATE	STEP	PRO	PROCEDURE CHANGE			Ву		Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No					itegory:						
	R				tion: (ed:		Date: _	
NCR:		\	WORK C	R	DER NON-CONFORMANO	CE (NO	CR)				
DATE	OTED	Description of NC		Corrective Action Section B			Verification		tion	Approval	Approval
DATE	STEP	Section A	Initial Chief En		Action Description Chief Eng	Sigi Da		Section		Chief Eng	QC Inspector
			;							<u> </u>	
				1							
					1						



Dart Ae	rospace	Ltd						•				
W/O:			V	WORK ORDER CHANG	GES							
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #:	1									
	R	esolution:	Disposi	ition:	QA: N/C Clo	sed:	Date: _					
NCR:			WORK OR	RDER NON-CONFORM	IANCE (NCR)							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Secondary Action Description	ction B Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspecto				
	,	COUNTY	Chief Eng	Chief Eng	Date	Jection 0	Office Ling	QO MODOOLO				
							·					
	į											



Dart Ae	rospace Li	td									
W/O:				WOF	RK ORDER CHANG	GES		-			ř
DATE	STEP	PR	OCEDURE	CHANG	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	o:	PAR #:	Fault	Catego	ory:	_ NC	R: Yes	No [QA:	Date: _	
	Resc	olution:	Dispo	sition:		QA	: N/C C	losed:		Date: _	
NCR:			WORK O	RDE	R NON-CONFORM	ANCE	E (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B		tion B		Vei	rification	Approval	Approva
DATE	SIEF	Section A	Initial Chief En		Action Description Chief Eng	···- <u>-</u> -	Sign Date	& S	Section C	Chief Eng	QC Inspecto
									•		
		-									
			-								
		·			·						
							ļ				



Dart Ae	rospace	e Ltd								
W/O:			1	WORK ORDER CHANG	ES					- -
DATE	STEP	F	PROCEDURE C	HANGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault C	ategory:	_ NCR:	Yes	No DQA :		Date:	
				ition:						
NCR:			WORK OF	DER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	on B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Verification Section C		Chief Eng	Approval QC inspector

DART AEROSPACE LTD	Work Order:	67955
Description: Blacker Fun R.H.	Part Number:	03199-4
Inspection Dwg:D 3191-4, Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
- 615	7/2 .010	(6)	>-		V Boz	
395	7	. 3 43	7		V	
507)	UD. 14	602,	8		V	
3,750	1/2 010	2.751	8		V	
	4/ -010	4.006	7		V	
8.030	41_ 00	8,033	1		V	
,990	4 .00	991	>		V	
3,68	4 -32	3,003	4	-	V	
3,64	71. OU	3,637	7	ļ	٧	
4.02	الا . ما	4.018	>=		V	
.040	7L .010	, ७३५	<u> </u>	,	V	
	·			ļ		
						· · ·
	·					
		,				

Measured by:	B	Audited by:	2	Prototype Approval:	
Date:	11-4-8	Date:	11/04/05	Date:	

-					•
				Revised by	Approved 1
	Rev	Date "	Change		
			Niew Jeeus	KJ/JLM	L
	А		New Issue		